

Tuesday, 09/12/2008 9:39:03 AM

User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 43955
Estimate Number : 13678
P.O. Number :
This Issue : 09/12/2008 **S.O. No.** :
Prsht Rev. : NC
First Issue : / / **Type** : R&D THERMOFORMING
Previous Run :
Written By :
Checked & Approved By : JLD 08.12.09
Comment : Est. Rev. A. 08.12.03 New Issue DL

Drawing Name : HAT BIN (206 L3/L4)
Part Number : D38501
Drawing Number : D3850-1
Project Number : IN0002
Drawing Revision : PROTOTYPE
Material : MKYD6185S080P362015
Due Date : 16/12/2008 **Qty:** 1 **Um:** Each

- PROTOTYPE
 08.12.22

Additional Product

PROTOTYPE

Job Number:


 UPDATED
 08.12.22

Seq. #: **Machine Or Operation:** **Description :** **PER TEST 08.12.16**

0.0 MKYD6185S080P362015 6185 KYDEX .080"


 MATERIAL CERTIFICATION
 REQ'D UPON DELIVERY


Comment: Qty.: 10.8056 sf(s)/Unit Total : 10.8056 sf(s)
 6185 Kydex .080" M. 109703 DL 08.12.08

1.0 HAND FINISH TH HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Machine set up

DL 08.12.08

2.0 HAND FINISH TH HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Cut sheet to required blank size

DL 08.12.08

3.0 THERMOFORMING THERMOFORMING MACHINE



Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D3850-1 and folio (FTA9338 Prototype) using tool DT 9338

Dwg. Rev. A PROTOTYPE
 Folio Rev. A

DL 08.12.08

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

DL 08.12.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HAT BIN (206 L3/L4)

Job Number: 43955

Part Number: D38501

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

6.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

SEE

FRI

08.12.12

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08.12.12

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

FOR ENGINEERING USE ONLY

NOT FOR STOCK 08.12.22

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.12.16 Prototype with
Deviations per
FRI Attached
08.12.24

Job Completion



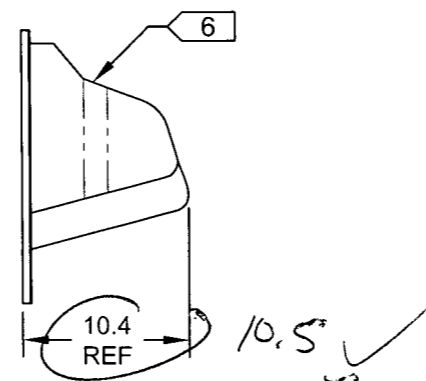
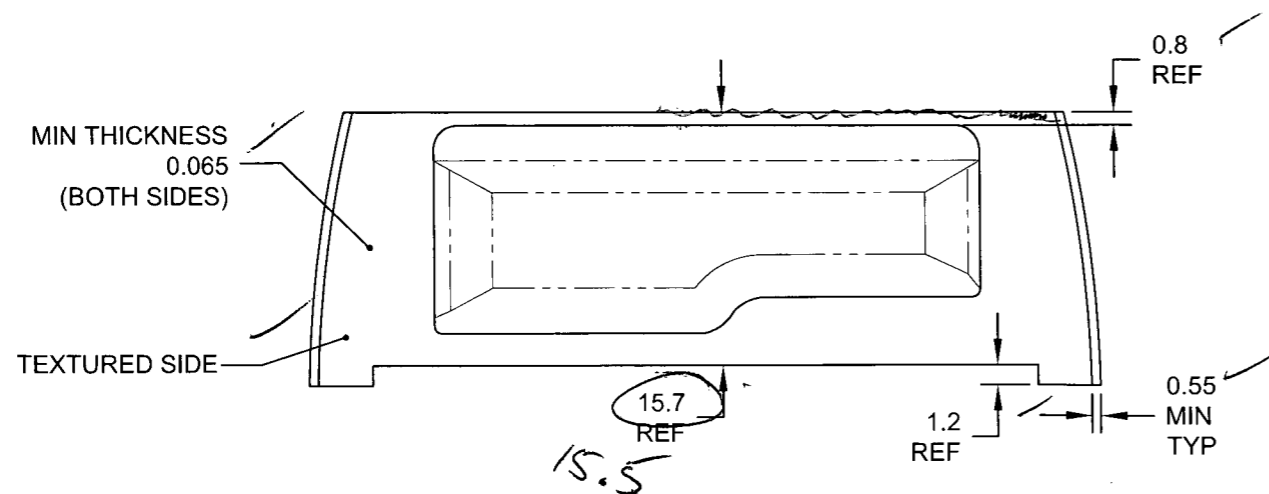
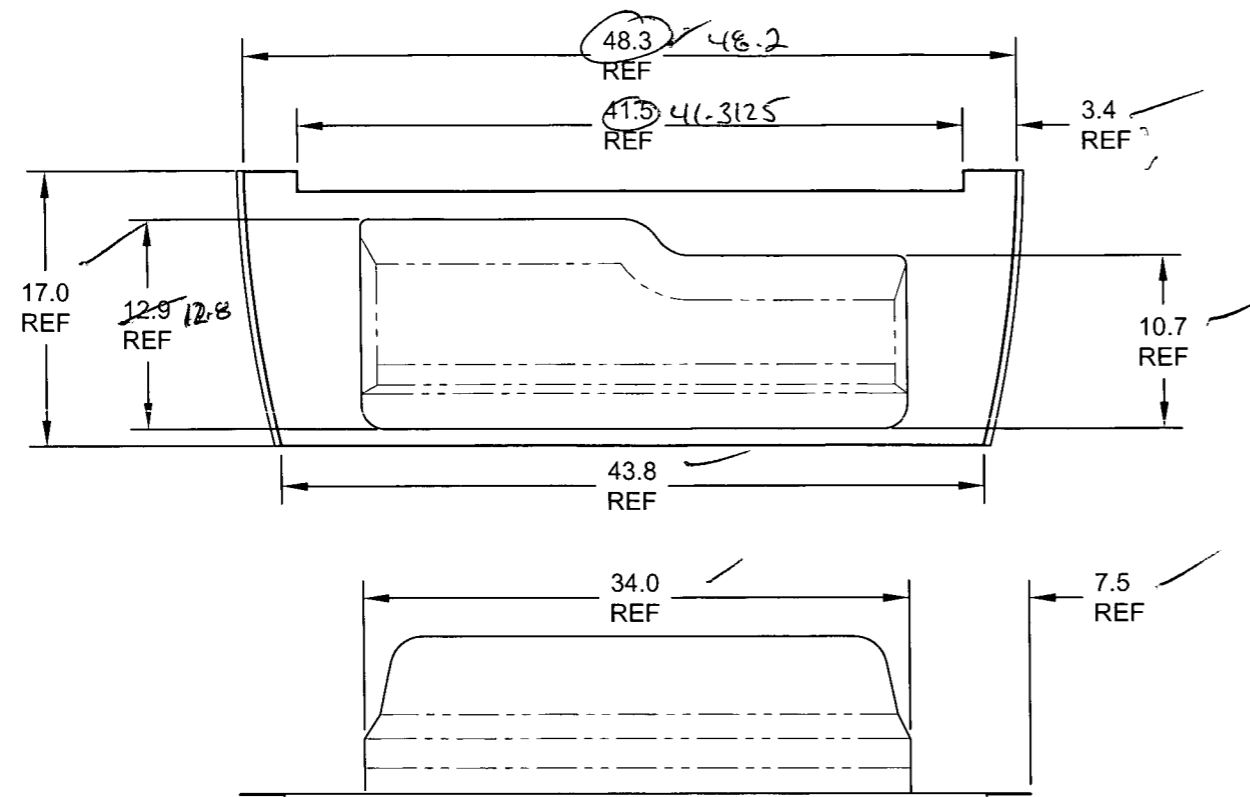
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3850-1 HAT BIN

NOTES:

- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
(REF DART SPEC MKYDEX6185S.080-P3-62015)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3850-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 4.0 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9338 PER DART QSI 022. TRIM PER MOLD

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
08.12.08 *ACL*

A	NEW ISSUE	PH	08.10.20
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3850	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		HAT BIN	NTS
DATE	08.10.20	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	


DART AEROSPACE LTD		Work Order: 43955
Description: Hot Bin / Prototype		Part Number: D3850-1
Inspection Dwg: D3850 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

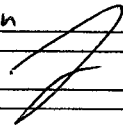
THERMOFORMING SECTION



Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			thin in corners (deep corners)


Measured by:  Date: 08.12.12

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
17.0 (Ref)	± 0.100	17.0	✓			
12.9 (Ref)	± 0.100	12.8	✓			at the most.
41.5 (Ref)	± 0.100	41.3125		✓		Review dim.
48.3 (Ref)	± 0.100	48.2	✓			at the most
34.4 (Ref)	± 0.100	34	✓			
43.8 (Ref)	± 0.100	43.8	✓			
10.7 (Ref)	± 0.100	10.75	✓			
34.0	± 0.100	33.8		✓		Review dim.
7.5	± 0.100	7.5	✓			
0.8	± 0.100	0.9	✓			
0.55	Min	0.55	✓			
0.065	Min	0.065	✓			at it's minimum.

Measured by:  Date: 08.12.12

Audited by:  Date: 

Prototype Approval:  Date: 06.12.16

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

Receiving Report

Dates:

Batch No:

Supplier:

Dart P/O:

Packing Slip:

Yes

No

Invoice:

Yes

No

Receipt:

Cash

Cr

Release Note Attached:

Yes

No

N/A

Waybill Attached:

Yes

☒ No

Shipment Complete

Yes

No

N/A

QC6 Inspection

Work Order

N/A

N/A

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12

Admin:

Location

سابك
sabic

SABIC Polymershapes

250 OLD INNES RD. 519 OTTAWA, ONT. K1B 5L3
TEL: 613 745 7043 FAX: 613 745 8163

CERTIFICATE OF COMPLIANCE

SOLD TO: DART AEROSPACE

DATE: 10/3/2008

YOUR PURCHASE ORDER : 7280

OUR SHIPPER NO: 084287

LINE ITEM # : 1

QUANTITY: 51

54 804287

08/01/27

DESCRIPTION: .080 x 48 x 96 Kydex 6185-P3 IVORY 62015.

THESE PARTS WERE MANUFACTURED IN ACCORDANCE WITH: FAR 25.853 (a)

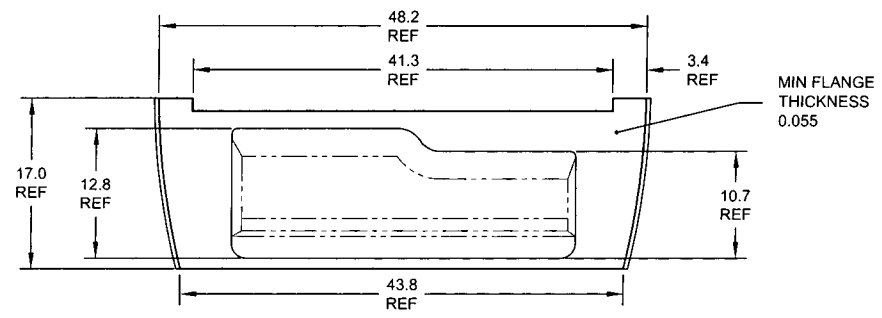
THIS IS TO CERTIFY THAT THE MATERIAL FINISHES AND FUNCTIONAL REQUIREMENTS OF THE ABOVE LISTED PARTS ARE IN ACCORDANCE WITH THE REFERENCE PROCUREMENT SPECIFICATIONS, CONTROL DRAWINGS OR PARTS DESIGNATION AND LATEST REVISIONS AS REFERENCED ON THE SUBJECT PURCHASE ORDER.

AUTHORIZED REPRESENTATIVE SIGNATURE

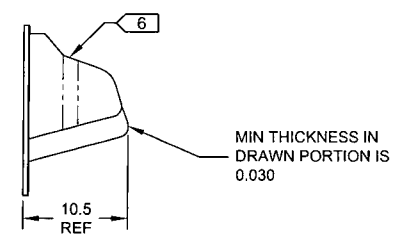
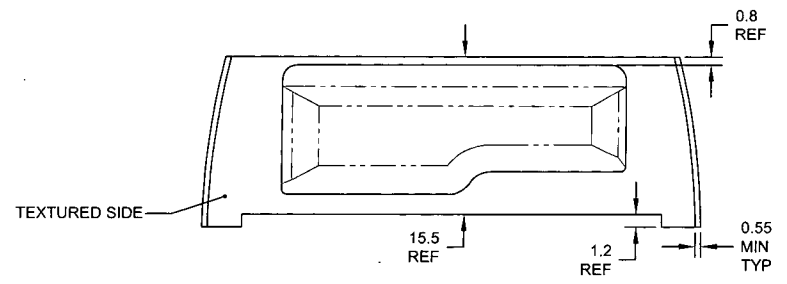
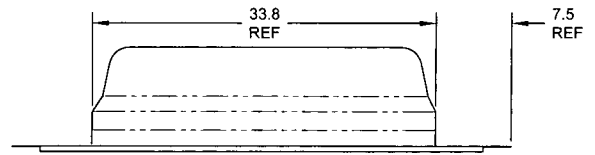
Jon Caldwell

JON CALDWELL
BRANCH MANAGER

8 7 6 5 4 3 2 1



MIN FLANGE
THICKNESS
0.055



D3850-1 HAT BIN
(BELL 206 L3/L4)

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
08.12.22 PH
REVISED FROM 08.12.03 DWG
TO UPDATE DIMENSIONS
PER FAI SHEET

- NOTES:**
- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
(REF DART SPEC MKYD6185S.080-P3-62015)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3850-1" USING VIBRATING STYLUS
 - 7) WEIGHT: 2.9 lbs
 - 8) TOOLING: THERMOFORM PER MOLD DT9338 PER DART QSI 022. TRIM PER MOLD

REV.	NEW ISSUE	PH	08.10.20
DESIGN	PH	BY	DATE
DRAWN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3850	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		HAT BIN (BELL 206 L3/L4)	NTS
DATE	08.10.20	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS COVENANT THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8 7 6 5 4 3 2 1